

**Work Order ID 67002**

Thursday, March 03, 2011 10:46:19 AM



Page 1

Item ID: D3245-043

Accept



Setup Start



Revision ID:

Item Name: Door Assembly

Stop



Start Date: 3/3/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 3/7/2011 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan:

Date: 11/03/3

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D3245

Rev B

100



Packaging

Packaging

Pick Kit

0.00

110



Small Fab

Small Fab

0.00

Small Fab

Memo  
1-Install Studs and Gromets as per Dwg D3245 3-Bond Gasket using 3M  
ADHESIVE as per Dwg D3245 A/R 3M 1300/1300L ADHESIVE  
Batch: M115230

0.00

120



QC

QC5- Inspect part completeness to step on W/O

0.00

Quality Control

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Required Date: 3/7/2011 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center ID

130

Operation  
DescriptionIdentify as per dwg & Stock Location: 233A

Packaging

Packaging

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

11/4/12SP/38

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/4/12MF  
11-04-10

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# Picklist Print

Thursday, March 03, 2011 10:46:28 AM

Page 1

Work Order ID: 67002



Parent Item: D3245-043



Parent Item Name: Door Assembly

Start Date: 3/3/2011

Required Date: 3/7/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev :A New Issue 07-09-11 JLM Verified By:EC  
IPP Rev:b ECN 1052 07-10-31 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
127H-35 		Purchased	No			100	Each	5.0000	8	40		<i>SB 11/04/11</i>	
HALF GROMMET				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			<i>40</i>	
				ST378			5	<i>B117203</i>					
					116049		5						
2351-20-009-C3Y 		Purchased	No			110	Each	70.0000	8	40		<i>SB 11/04/11</i>	
STUD				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			<i>40</i>	
				ST399			70	<i>M117358</i>					
					106484		1						
					110944		50						
					111733		13						
					15447		6						
D3245-3 		Manufactured	No			110	Each	10.0000	1		<i>SB 11/03/07</i>		
Door				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST233			6						
					63604		6					<i>1</i>	
					ST233A		4						
						63598	4					<i>4</i>	

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**Parent Item:** D3245-043



**Parent Item Name:** Door Assembly

**Start Date:** 3/3/2011

**Required Date:** 3/7/2011

**Start Qty:** 5.00

**Required Qty:** 5.00

D3245-7



Manufactured No

110

Each

5.0000

1

5

Gasket



*Eduardo*  
3/3/07

5

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST233B	5	
63366	5	

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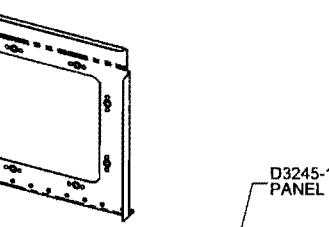
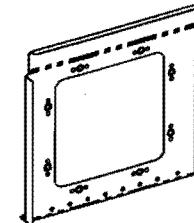
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 670020711-03-3

D3245-2 PANEL



2350-18-C3Y DZUS  
RIGID RECEPTACLE (1)  
MS20427M3-3 RIVET (2)  
(8 PLACES)

2350-18-C3Y DZUS  
RIGID RECEPTACLE (1)  
MS20427M3-3 RIVET (2)  
(8 PLACES)

D3245-1 PANEL

D3245-2 PANEL

2350-18-C3Y DZUS  
RIGID RECEPTACLE (1)  
MS20427M3-3 RIVET (2)  
(8 PLACES)

2350-18-C3Y DZUS  
RIGID RECEPTACLE (1)  
MS20427M3-3 RIVET (2)  
(8 PLACES)

D3245-1 PANEL

D3245-2 PANEL

UP  
FWD

UP  
FWD

MS20615M3-3 RIVET  
(9 PLACES)

MS20615M3-3 RIVET  
(9 PLACES)

#### D3245-041 ACCESS PANEL ASSEMBLY

RELEASED  
07-10-23

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3245-041	ACCESS PANEL ASSEMBLY, LH
X		D3245-042	ACCESS PANEL ASSEMBLY, RH
1		D3245-1	PANEL
1	1	D3245-2	PANEL
1	1	D3245-5	ANGLE PLATE
8	8	2350-18-C3Y	DZUS RIGID RECEPTACLE
16	16	MS20427M3-3	RIVET
9	9	MS20615M3-3	RIVET

NOTES:  
 1) MATERIAL: N/A  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002  
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-XX" AND B/N "XXXXXX" USING FINE POINT PERMANENT INK MARKER  
 7) WEIGHT: 0.83 lbs

#### D3245-042 ACCESS PANEL ASSEMBLY

B	REMOVE Ø0.204 HOLES FROM D3245-1/-1F. REMOVE MS21080-L2K NUTPLATES & DURABLA BLACK GASKETS FROM D3245-041/042. HOLES AND ITEMS ARE NOW PART OF INSTALLATION. ASSIGN P/Ns TO GASKETS & REFORMAT DRAWING	MB	07.10.02
A	NEW ISSUE	RF	04.01.27
REV. <u>1</u>			BY DATE
DESIGN <u>1F</u> DRAWN <u>1</u> CHECKED <u>PH</u> MFG. APPR. <u>DA</u> APPROVED <u>DA</u> DE APPR. <u>DA</u> DATE <u>07.10.02</u>			DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWING NO. <u>D3245</u> REV. B SHEET 1 OF 7			TITLE <u>ACCESS PANEL ASSEMBLY</u> SCALE <u>1:2.5</u>
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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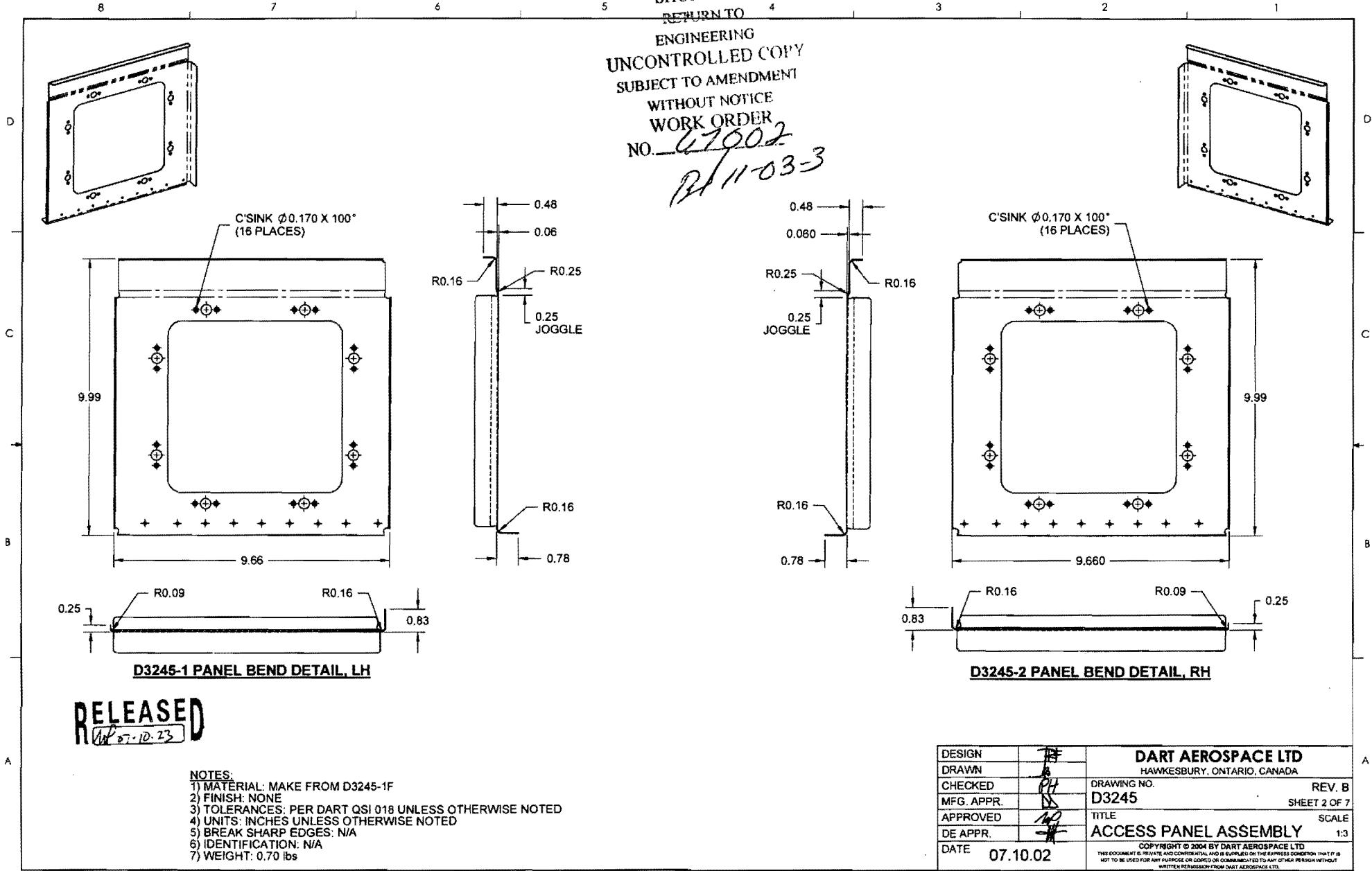
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. *67902*

*21/11/03-3*



DESIGN	<i>PF</i>	DART AEROSPACE LTD	
DRAVN	<i>8</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO.	
MFG. APPR.	<i>NA</i>	D3245	
APPROVED	<i>NA</i>	REV. B	
DE APPR.	<i>NA</i>	SHEET 2 OF 7	
DATE	07.10.02	TITLE	
		SCALE	
		ACCESS PANEL ASSEMBLY	

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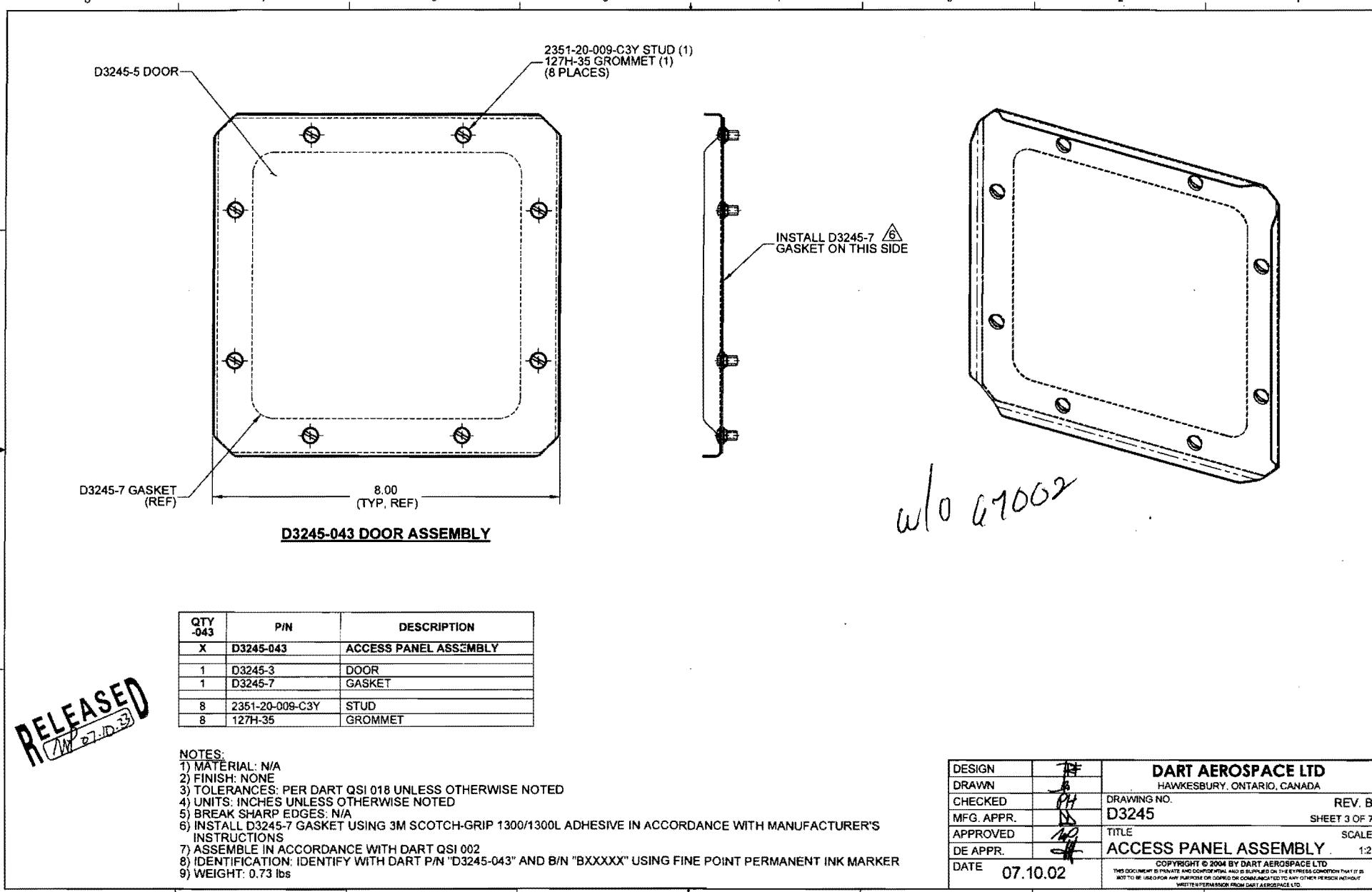
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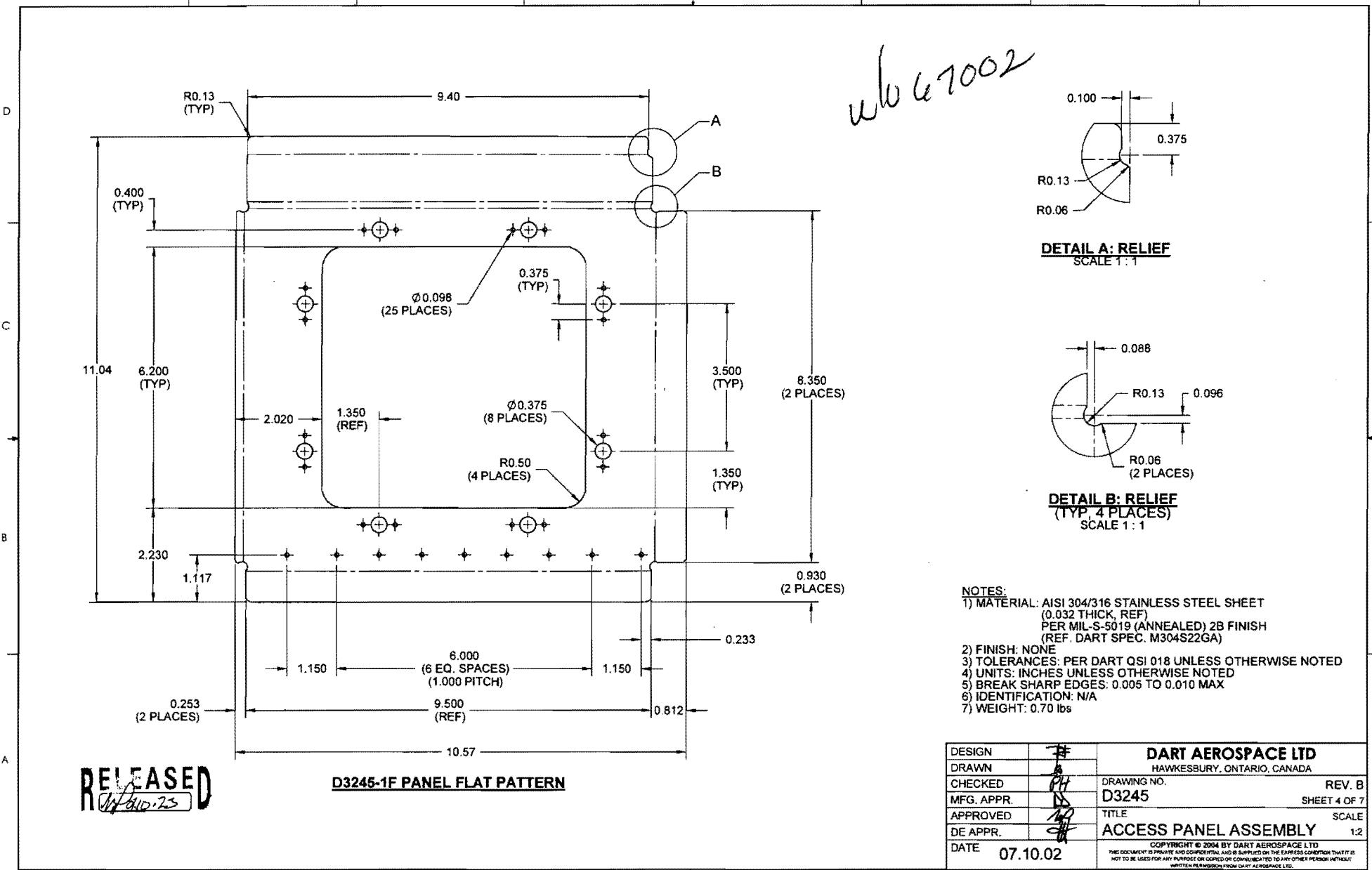
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RELEASED  
07/01/23

**D3245-1F PANEL FLAT PATTERN**

DESIGN	<u>FF</u>	DART AEROSPACE LTD		
DRAWN	<u>8</u>	HAWKESBURY, ONTARIO, CANADA		
CHECKED	<u>PH</u>	DRAWING NO.	REV. B	
MFG. APPR.	<u>DS</u>	DS3245	SHEET 4 OF 7	
APPROVED	<u>AP</u>	TITLE	SCALE	
DE APPR.	<u>SP</u>	ACCESS PANEL ASSEMBLY	1:2	
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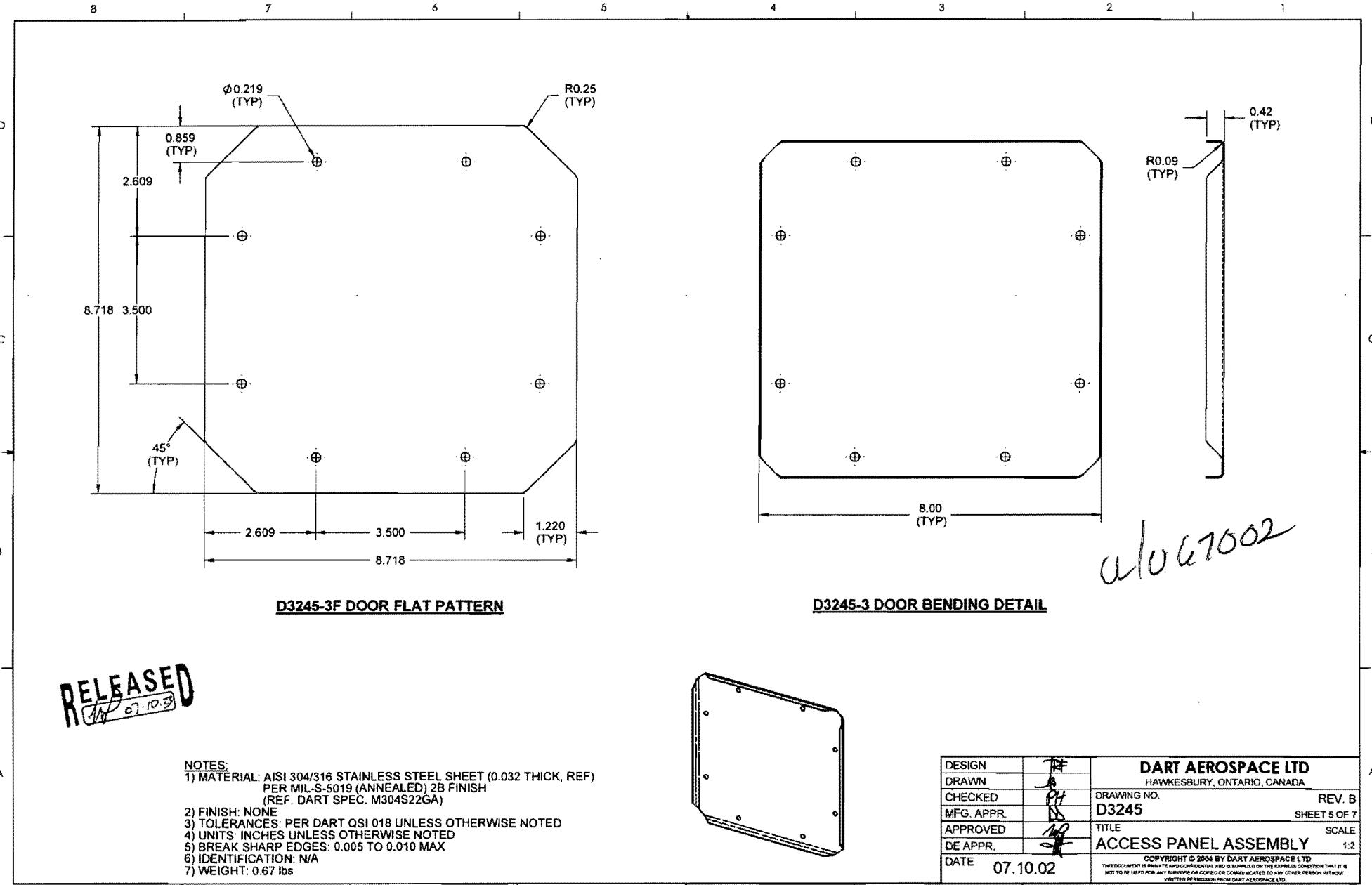
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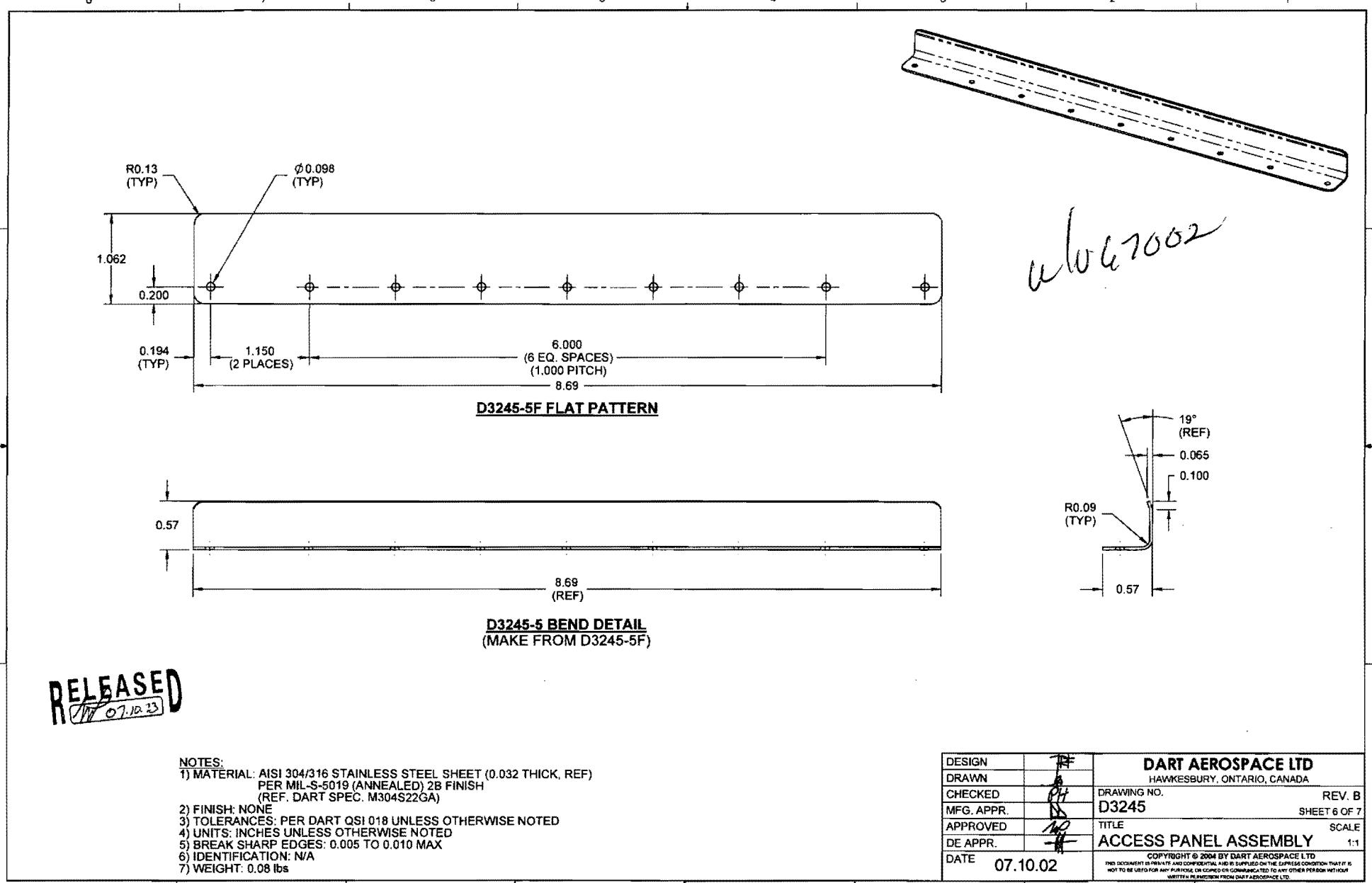
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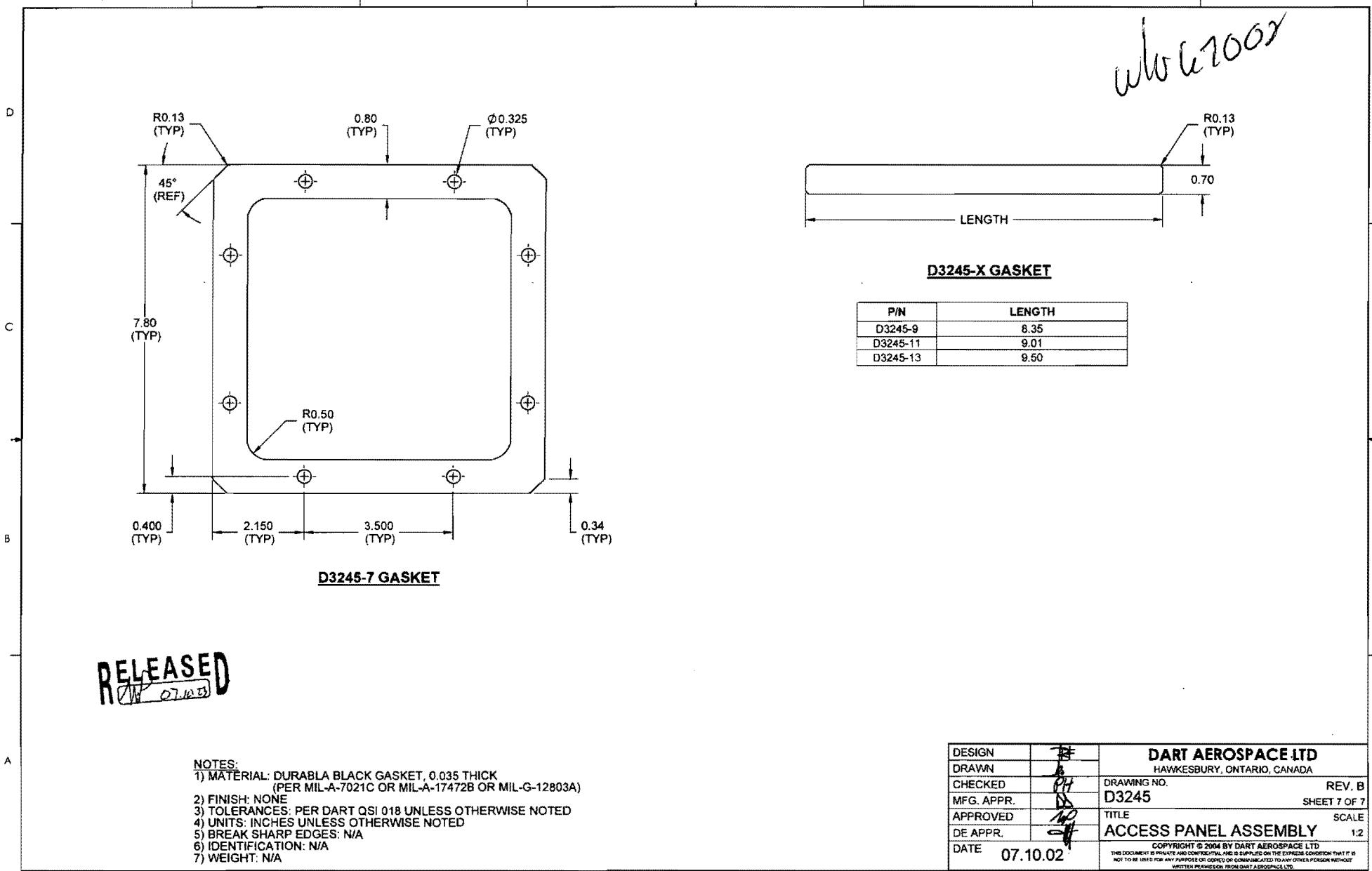
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8 7 6 5 4 3 2 1

WW61002



DESIGN	7F	DART AEROSPACE LTD	
DRAWN	3	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	DA	D3245	SHEET 7 OF 7
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